



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

20NR-86
Job Sheet 195628



Part No: 20NR-86

Job Qty: 1 pcs

Part Name: Dual Hook Cage Frame



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/27/19

Job Tracking No:

Due Date: 5/10/19

Created By: Eric Larocque

Type: SOLD

Description:

Note: DWG 20NR-86 Rev.1 IPP Rev. A 19.02.11 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Run Hrs	Workcenter/Supplier	Workcenter / Supplier Lead Time	Sign-off
110	Large Fab - Welded Assy-1	1 pcs	5/10/19		0.00	1.00	Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
Large Fab - 9									
115	QC 9	1 pcs	5/10/19		0.00	0.00	QC 9 - 10		MAY 29 2019
							QC 9 - 18		
							QC 9 - 24		
							QC 9 - 43		
							QC 9 - 50		
							QC 9 - 9		
120	QC 5	1 pcs	5/10/19		0.00	0.00	QC 5 - 10		MAY 29 2019
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
QC 5 - 9									
QC 5 - 50									

DART
AEROSPACE

Container No: S185029

Part: 20NR-86
Job No: 195628
Serial No/Batch: S185029
Revision: 1
Inspector:
Exp Date:
Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 05/29/19



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Part: 20NR-86

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Revision: 1

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Exp Date:

Instructions:

Date: 05/29/19

130 Powdercoat - 6 Fire Red - B4B 1 pcs	5/10/19	0.00 0.00	QC 5 - 30	
			Powdercoat - 1 - B4B	
			Powdercoat - 2 - B4B	
			Powdercoat - 3 - B4B	
			Powdercoat - 4 - B4B	
140 QC 3 1 pcs	5/10/19	0.00 0.00	QC 3 - 10	
			QC 3 - 13	
			QC 3 - 15	
			QC 3 - 17	
			QC 3 - 18	
			QC 3 - 2	
			QC 3 - 28	
			QC 3 - 3	
			QC 3 - 30	
			QC 3 - 34	
			QC 3 - 36	
			QC 3 - 41	
			QC 3 - 51	
			QC 3 - 58	
			QC 3 - 59	
			QC 3 - 68	
			QC 3 - 9	
180 Packaging 3-1 - Stock - B4B 1 pcs	5/10/19	0.00 0.00	Packaging 3 - 1 - B4B	
			Packaging 3 - 2 - B4B	
			Packaging 3 - 3 - B4B	
			Packaging 3 - 4 - B4B	
			Packaging 3 - 5 - B4B	
			Packaging 3 - 6 - B4B	
			Packaging 3 - 7 - B4B	
			Packaging 3 - 8 - B4B	
			Packaging 3 - 9 - B4B	
			Packaging 3 - 10 - B4B	
			Packaging 3 - 11 - B4B	
			Packaging 3 - 12 - B4B	
			Packaging 3 - 13 - B4B	
			Packaging 3 - 14 - B4B	
			Packaging 3 - 15 - B4B	
			Packaging 3 - 16 - B4B	
			Packaging 3 - 17 - B4B	
			Packaging 3 - 18 - B4B	
			Packaging 3 - 19 - B4B	
			Packaging 3 - 20 - B4B	
			Packaging 3 - 21 - B4B	
			Packaging 3 - 22 - B4B	
			Packaging 3 - 23 - B4B	
			Packaging 3 - 24 - B4B	
			Packaging 3 - 25 - B4B	
			Packaging 3 - 26 - B4B	
			Packaging 3 - 27 - B4B	
			Packaging 3 - 28 - B4B	
			Packaging 3 - 29 - B4B	
			Packaging 3 - 30 - B4B	
			Packaging 3 - 31 - B4B	
			Packaging 3 - 32 - B4B	
			Packaging 3 - 33 - B4B	
			Packaging 3 - 34 - B4B	
			Packaging 3 - 35 - B4B	
			Packaging 3 - 36 - B4B	
190 QC 21 - SA 1 pcs	5/10/19	0.00 0.00	QC 21 - SA - 21	

11/29/23
 START: 11:35
 CV: 1:30' FIVISA 12:05

19-5 30

DAS
 MAY 30 2019 68
 9-89

DAS 30 9-89
 MAY 30 2019

DAS
 21 MAY 31 2019
 9-89

QC 21 - SA - 70

QC 21 - SA - 53

Part Op **110** - 1-Weld as per DWG. Use 8/20NR jig to assemble. 3/8" welds on all parts. See note 1 and 2.
 Descriptions: **115** - (QC9- Inspect visual per QSI004- Fusion Welds)

120 - (QC5- Inspect part completeness to step on W/O)

130 - Fire Red(Ref:4.3.5.10) per QSI005 4.3) START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____

140 - (QC3- Inspect Part Finish)

180 - (Identify as per dwg & Stock Location: _____)

190 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
20NR-119-1	Bracket	2 pcs (2 ea)	110-Large Fab - Welded Assy-1	5176244
20NR-119-10	Support Tubing	2 pcs (2 ea)	110-Large Fab - Welded Assy-1	573610
20NR-119-2-DHC	DHC Back Plate	1 pcs (1 ea)	110-Large Fab - Welded Assy-1	5168407
20NR-119-3P	Feeder Support Bracket	4 pcs (4 ea)	110-Large Fab - Welded Assy-1	5183445
20NR-119-4	Left Top Feeder	2 pcs (2 ea)	110-Large Fab - Welded Assy-1	5168401
20NR-119-4B	Bottom Left Feeder	2 pcs (2 ea)	110-Large Fab - Welded Assy-1	5164329
20NR-119-5	Top Right Feeder	2 pcs (2 ea)	110-Large Fab - Welded Assy-1	5164382
20NR-119-5B	Bottom Right Feeder	2 pcs (2 ea)	110-Large Fab - Welded Assy-1	5164335
20NR-119-6	Upper Funnel Guide	4 pcs (4 ea)	110-Large Fab - Welded Assy-1	5168821
20NR-119-7	Lower Funnel Guide	4 pcs (4 ea)	110-Large Fab - Welded Assy-1	5170080
20NR-119-8	Front Support	4 pcs (4 ea)	110-Large Fab - Welded Assy-1	5183205
20NR-119-9-DHC	Guard	1 pcs (1 ea)	110-Large Fab - Welded Assy-1	5173554
20NR-120-5	Funnel Tab	2 pcs (2 ea)	110-Large Fab - Welded Assy-1	5164391

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Large Fab - Welded Assy-1	20NR-119-1	2	19	0
	20NR-119-10	2	4	0
	20NR-119-2-DHC	1	2	0
	20NR-119-3P	4	0	0
	20NR-119-4	2	6	0
	20NR-119-4B	2	4	0
	20NR-119-5	2	6	0
	20NR-119-5B	2	4	0
	20NR-119-6	4	8	0
	20NR-119-7	4	14	0
	20NR-119-8	4	8	0
	20NR-119-9-DHC	1	2	0
	20NR-120-5	2	7	0

Part Specifications

Specifications could not be found.